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D350-607-511
Job Sheet 182359



SPK 4/5

Part No: D350-607-511

Job Qty: 6 ea

Part Name: AS350/AS355 Quick Release Basket/Long Cargo Tube Mounting Provisions, Fits LH/RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/23/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP REV:A NEW ISSUE 10-06-28 JLM VERIFIED BY: LL IPP REV:B 13.12.30 PER RE.C
ECN13-672 DD VERF:RQ IPP REV:C 14.06.09 AS PER ECN14-572 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Stores/Pkg-2		AUG 24 2018
140	Packaging	6 pcs	9/7/18	9/7/18	0.00	0.00	Packaging1-3		AUG 28 2018
150	QC	6 pcs	9/7/18	9/7/18	0.00	0.00	QC4		AUG 28 2018
160	Packaging	6 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-1		AUG 28 2018
165	DC	6 pcs	9/7/18	9/7/18	0.00	0.00	DC		AUG 28 2018
170	QC21-FG	6 Ea	9/7/18	9/7/18	0.00	0.00	QC21		AUG 28 2018

Part Op 165 - Photocopy bluefile & type labels per PPP D350-607-511 CHG007
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-14A	Bolt	120 Ea (20 ea)	90-Start up Operation	5061888x2 5094583x118
AN4-42A	Bolt	24 Ea (4 ea)	90-Start up Operation	5067890x20 5094570x4
AN6-13A	Bolt	12 Ea (2 ea)	90-Start up Operation	50711001
D3501-1	Bushing	48 Ea (8 ea)	90-Start up Operation	5072799x27
D3910-3	Crosstube Lug	12 Ea (2 ea)	90-Start up Operation	067434
D3910-5	Crosstube Lug	6 Ea (1 ea)	90-Start up Operation	067439
D3910-7	Crosstube Lug	6 Ea (1 ea)	90-Start up Operation	895x2 510249 4x4
D3984-030	Rubber Extrusion, X-tube, 3"	48 Ea (8 ea)	90-Start up Operation	5077602
D4148-041	Fwd Crosstube Lug Assembly	6 Ea (1 ea)	90-Start up Operation	50916771 5004016 4x5
D4149-041	Aft Crosstube Lug Assembly	6 Ea (1 ea)	90-Start up Operation	4x4 5003996 10
D4775-041	Strut Assembly	12 Ea (2 ea)	90-Start up Operation	104040
D4776-3	Skidtube Clevis	12 Ea (2 ea)	90-Start up Operation	5020810 509563 0x2 0
MS21042L4	Nut	144 Ea (24 ea)	90-Start up Operation	5099365
MS21042L6	Nut	12 Ea (2 ea)	90-Start up Operation	5067066
NAS1149F0432P	Washer	240 Ea (40 ea)	90-Start up Operation	5083558
NAS1149F0663P	Washer	24 Ea (4 ea)	90-Start up Operation	5051477
D4085-3	Placard	6 Ea (1 ea)	90-Start up Operation	5082411 50976 4x5
D4713-1	Spacer	6 Ea (1 ea)	90-Start up Operation	5095336
MS3367-5-0	Tie Wrap	6 Ea (1 ea)	90-Start up Operation	5050161

Job Allocations

005160

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec./Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Date : _____ Step #: _____

IRB (QSI042) Approval

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

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Container No: S105970

Part: D350-607-511

Job No: 182359

Serial No/ Batch: S105970

Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: TC STC SH94 - 14 Issue 7 of 7

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/For ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	Operator ☐	Bending ☐	Feno/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	Offset/Setup ☐	Centre Not Cc ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	Training ☐	Crimp/Kink/Rip ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	Use for Testing ☐	Cuffs ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	Poor Information ☐	Crushing ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Mislabeled ☐	Finish ☐			
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Fit/Function ☐	Misread ☐			
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER : _____					

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-14A	120	417	0
	AN4-42A	24	95	0
	AN6-13A	12	91	0
	D3501-1	48	727	0
	D3910-3	12	31	0
	D3910-5	6	35	0
	D3910-7	6	28	0
	D3984-030	48	173	0
	D4085-3	6	14	0
	D4148-041	6	9	0
	D4149-041	6	9	0
	D4713-1	6	49	0
	D4775-041	12	19	0
	D4776-3	12	30	0
	MS21042L4	144	5,578	0
	MS21042L6	12	290	0
	MS3367-5-0	6	768	0
	NAS1149F0432P	240	2,035	0
	NAS1149F0663P	24	808	0

Part Specifications

Specifications could not be found.

Plex 8/23/18 8:51 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause				FAULT CATEGORY					
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

5.0 PARTS LIST

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET
	X					D350-607-543	HELI-UTILITY-BASKET
		X				D350-607-545	HELI-UTILITY-BASKET
			X			D350-607-547	HELI-UTILITY-BASKET
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT
					X	D350-607-501	CONVERSION KIT
1	1	1	1		1	D2690-6	LANYARD
				8	8	D3501-1	BUSHING
				2	2	D3910-3	X-TUBE LUG
				1	1	D3910-5	X-TUBE LUG
				1	1	D3910-7	X-TUBE LUG
1	1	1	1		1	D3912-041	EYEBOLT RECEIVER ASSY
				8	8	D3984-030	RUBBER EXTRUSION, X-TUBE
1						D4030-041	LONG BASKET ASSY
	1					D4030-043	LONG BASKET ASSY, LIGHTWEIGHT
		1				D4032-041	SHORT BASKET ASSY
			1			D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
1					1	D4917-300	PLACARD, MAX LOAD
1						D4086-200	PLACARD, MAX LOAD
	1				1	D4917-315	PLACARD, MAX LOAD
	1					D4086-215	PLACARD, MAX LOAD
		1			1	D4917-320	PLACARD, MAX LOAD
		1				D4086-220	PLACARD, MAX LOAD
			1		1	D4917-332	PLACARD, MAX LOAD
1	1	1	1	1	1	D4085-3	PLACARD, INSTRUCTIONS
			1			D4086-232	PLACARD, MAX LOAD
				1	1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4149-041	AFT X-TUBE LUG ASSY
1	1	1	1		1	D4150-041	ATTACHMENT ARM ASSY
1	1	1	1		1	D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
1	1	1	1		1	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
				1	1	D4713-1	SPACER
				2	2	D4775-041	STRUT ASSEMBLY
				2	2	D4776-3	SKIDTUBE CLEVIS
6	6	6	6		6	AN4-13A	BOLT
				20	22	AN4-14A	BOLT
				4	4	AN4-42A	BOLT
1	1	1	1		1	AN4C15	BOLT
1	1	1	1		1	AN310C4	CASTELLATED NUT
				2	2	AN6-13A	BOLT
1	1	1	1		1	MS17984-C413	QUICK RELEASE PIN
6	6	6	6	24	32	MS21042L4	NUT (OR MS21042-4)
				2	2	MS21042L6	NUT
1	1	1	1		1	MS24665-151	COTTER PIN
				1	1	MS3367-5-0	TIE WRAP
2	2	2	2		2	NAS1515H4L	WASHER
12	12	12	12	40	56	NAS1149F0432P	WASHER
3	3	3	3		3	NAS1149C0463R	WASHER
				4	4	NAS1149F0663P	WASHER

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